

NCR-19-7527



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3637-3
Job Sheet 192300-A



Part No: D3637-3

Job Qty: 8 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/15/19

Job Tracking No:

Due Date: 6/10/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Ship Via:

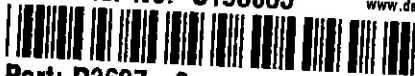
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC 8	8 pcs		6/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	8 pcs		6/10/19	0.06	1.01	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	8 pcs		6/10/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		



Container No: S198065



Part: D3637-3
Job No: 192300-A
Serial No/Batch: S197493

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/16/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

DAS 30 32

JUL 12 2019

				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS JUL 15 2019 40 9-89
150 Small Fab - 2 - B4B	8 pcs	6/10/19	0.00 2.41	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	JUL 16 2019
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
160 QC 5	8 pcs	6/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS JUL 16 2019 40 9-89
					BEB 19-07-16
170 Handfinish - 1-1 Chemical-B4B	8 pcs	6/10/19	0.00 0.34	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	8	6/10/19	0.00 0.00	QC 7 - 10	

pcs

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

DAS
61
9-89

190 Packaging 3-1 - Stock - B4B

8
pcs

6/10/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

200	QC 21 - SA	8	6/10/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Small Fab)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Chemical Conversion Coat per QSI005 4.1)
 180 - (QC7-Inspect Chemical Conversion Coat)
 190 - (Identify as per dwg & Stock Location: 5+045)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	4.500Inches ± 0.030	4.530 4.470		
2	Bracket	4.970Inches ± 0.030	5.000 4.940		
3	Bracket	0.050Inches ± 0.010	0.060 0.040		

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D3637-3

Job Sheet 192300



Part No: D3637-3

Job Qty: 12 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		4/12/19	0.00	0.61	Waterjet - Flow		JRB 7/11/19
120	QC 8	12 pcs		4/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	12 pcs		4/12/19	0.06	1.51	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		

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140 QC 5	12 pcs	4/12/19	0.00 0.00	B4B					
				QC 5 - 10					
				QC 5 - 12					
				QC 5 - 17					
				QC 5 - 18					
				QC 5 - 19					
				QC 5 - 22					
				QC 5 - 24					
				QC 5 - 3					
				QC 5 - 43					
				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				QC 5 - 68					
				QC 5 - 9					
				QC 5 - 50					
				QC 5 - 30					
				QC 5 - 40					
				150 Small Fab - 2 - B4B	12 pcs	4/12/19	0.00 3.61	Small Fab - 1 - B4B	
								Small Fab - 2 - B4B	
Small Fab - 3 - B4B									
Small Fab - 4 - B4B									
Small Fab - 5 - B4B									
Small Fab - 6 - B4B									
Small Fab - 7 - B4B									
160 QC 5	12 pcs	4/12/19	0.00 0.00	QC 5 - 10					
				QC 5 - 12					
				QC 5 - 17					
				QC 5 - 18					
				QC 5 - 19					
				QC 5 - 22					
				QC 5 - 24					
				QC 5 - 3					
				QC 5 - 43					
				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				QC 5 - 68					
				QC 5 - 9					
				QC 5 - 50					
				QC 5 - 30					
				QC 5 - 40					
170 Handfinish - 1-1 Chemical-B4B	12 pcs	4/12/19	0.00 0.51	Handfinish - 1 - 1 - B4B					
				Handfinish - 1 - 2 - B4B					
				Handfinish - 1 - 3 - B4B					
				Handfinish - 1 - 4 - B4B					
				Handfinish - 1 - 5 - B4B					
				Handfinish - 1 - 6 - B4B					
				Handfinish - 1 - 7 - B4B					
				Handfinish - 1 - 8 - B4B					
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B					
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 - B4B					
				Plex 3/21/19 7:23 AM Dart.lajeunesse.marie					

180 QC 7	12 pcs	4/12/19	0.00 0.00	Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
190 Packaging 3-1 - Stock - B4B	12 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	12	4/12/19	0.00	0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Form as per dwg)
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 150 - (Small Fab)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Chemical Conversion Coat per QSI005 4.1)
 180 - (QC7-Inspect Chemical Conversion Coat)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.6080 sf (.134 ea)	100-Waterjet - Flow - 1	5155269

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	2	43	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	4.500Inches ± 0.030	4.530 4.470		
2	Bracket	4.970Inches ± 0.030	5.000 4.940		
3	Bracket	0.050Inches ± 0.010	0.060 0.040		

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Entered: Oct 24/19 Date: 2K

NCR No. 19-7527

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

Job: <u>192300 192300</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS					
Part No. <u>D3637-3</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		

Date: <u>JUL 16 2019</u>	Sequence #: <u>160</u>	QTY Affected: <u>1 of 7</u>	DAS 55 9-89
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Description Work Order Deviation	Disposition	Completed By
- Hole that was drilled out of center to the counter sink holes	Scrap no replace	40 9-89
		Lead hand / Supervisor
		DAS 30 9-89
		2019-07-16
		QC / QA Coordinator
		40 9-89
		JUL 16 2019

Root Cause	FAULT CATEGORY			
Operator ☒	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
Manufacturing Process ☐	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
Equip/Tooling ☐	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
Handling/Presservation ☐	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
Material ☐	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Product Improvement ☐	☐ Marks/Chatter	☒ Drill Holes	☐ Out of Sequence	☐ Misread
Process Improvement ☐	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
Human Factors ☐	Other/Details:			